

Work Order ID 52379

Page 2

Tuesday, September 22, 2009 11:48:49 AM

Item ID: D3514-043

Accept



Setup Start



Revision ID: A

Work Order ID 52379

Page 1

Tuesday, September 22, 2009 11:48:49 AM

Item ID: D3514-043

Accept



Setup Start



Revision ID: A

Stop



Item Name: Top Mounted Gimbal Assembly

Customer:

Start Date: 9/23/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: *W* Date: 09-9-22

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3514	Rev A

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D3514

9/10/09 10:01 ④

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

→ S(0)02|01

(x4)

Quality Control

120

0.00



Identify as per dwg & Stock Location:

Packaging

Memo

0.00

10-2-17 408

Packaging

Picklist Print

Page 1

Tuesday, September 22, 2009 11:48:48 AM

Work Order ID: 52379



Parent Item: D3514-043RevA



Parent Item Name: Top Mounted Gimbal Assembly

Start Date: 9/23/2009

Required Date: 10/9/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN3-6A



Purchased

No

100

Each

137.0000

4.0000



Bolt

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST	137	
112082	7	
112513	30	
112720	100	

AN960JD10L



Purchased

No

100

Each

6,445.000

8.0000



Washer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST	6445	
101291	16	
104885	153	
105793	236	
109632	1040	
110985	5000	

D3514-047RevA



Manufactured

No

100

Each

0.0000

4.0000



Top Mounted Housing Assembly

B50308 (2x)
B53021 (2x)

EP10/02/01
M113149 (44)
EP10/02/01
8
K09/02/14

Picklist Print

Page 3

Tuesday, September 22, 2009 11:48:48 AM

Work Order ID: 52379



Parent Item: D3514-043RevA



Parent Item Name: Top Mounted Gimbal Assembly

Start Date: 9/23/2009

Required Date: 10/9/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3533-3RevB



Manufactured

No

100

Each

176.0000

8.0000



Set Screw

Warehouse Loc Qty Loc CodeLocation

Main Warehouse

ST 176

34899 78

35024 98

*8/28/14**8/28/14*

MS24693-S29



Purchased

No

100

Each

208.0000

16.0000



Screw

Warehouse Loc Qty Loc CodeLocation

Main Warehouse

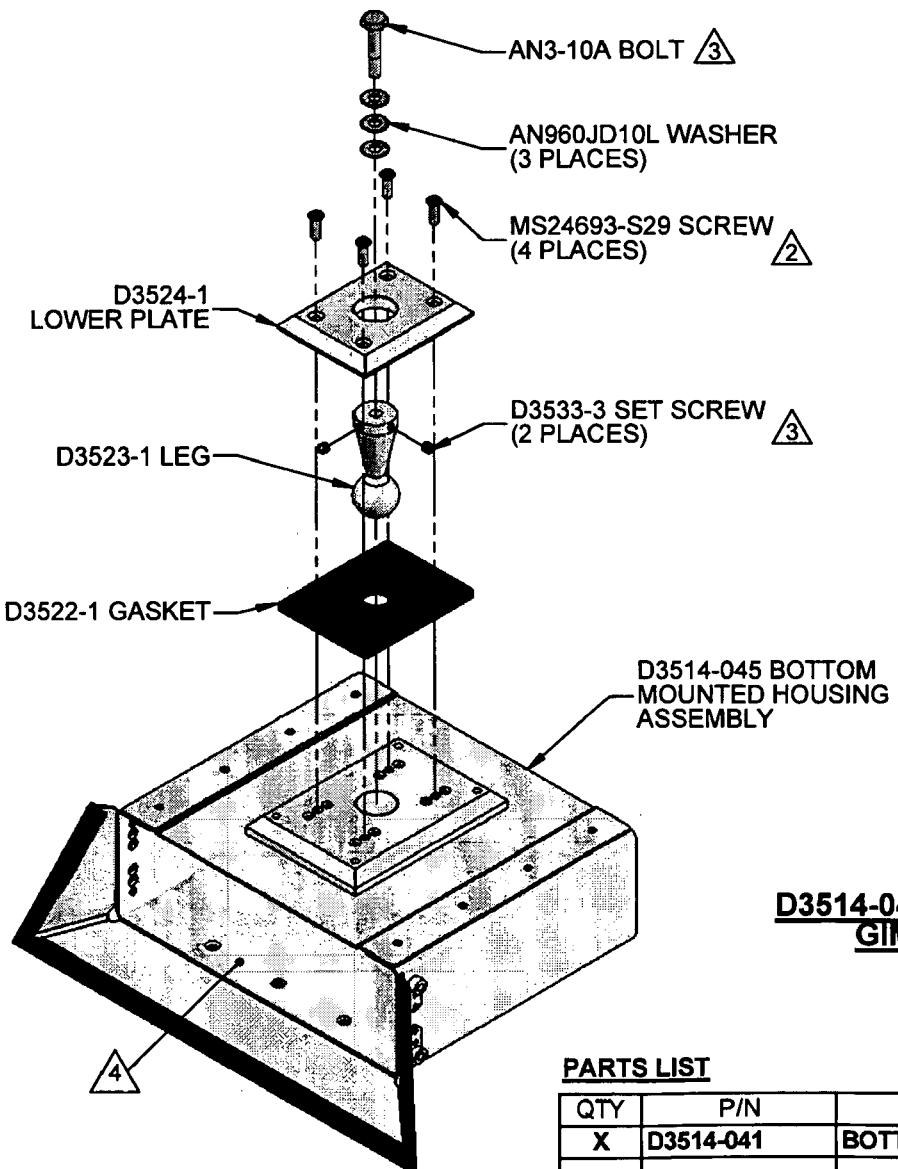
ST 208

103915 208

*8/28/14**8/28/14*

DART

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CHECKED <i>CE</i>	APPROVED <i>A</i>	DRAWING NO. D3514	REV. A	SHEET 1 OF 9
DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE	1:3
REV A	DATE 07.06.18	DESCRIPTION NEW ISSUE		



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WITHOUT NOTICE
WORK ORDER
NO. 52379

D3514-041 BOTTOM MOUNTED GIMBAL ASSEMBLY

PARTS LIST

QTY	P/N	DESCRIPTION
X	D3514-041	BOTTOM MOUNTED GIMBAL ASSEMBLY
1	D3514-045	BOTTOM MOUNTED HOUSING ASSEMBLY
1	D3522-1	GASKET
1	D3523-1	LEG
1	D3524-1	LOWER PLATE
2	D3533-3	SET SCREW
1	AN3-10A	BOLT
3	AN960JD10L	WASHER
4	MS24693-S29	SCREW

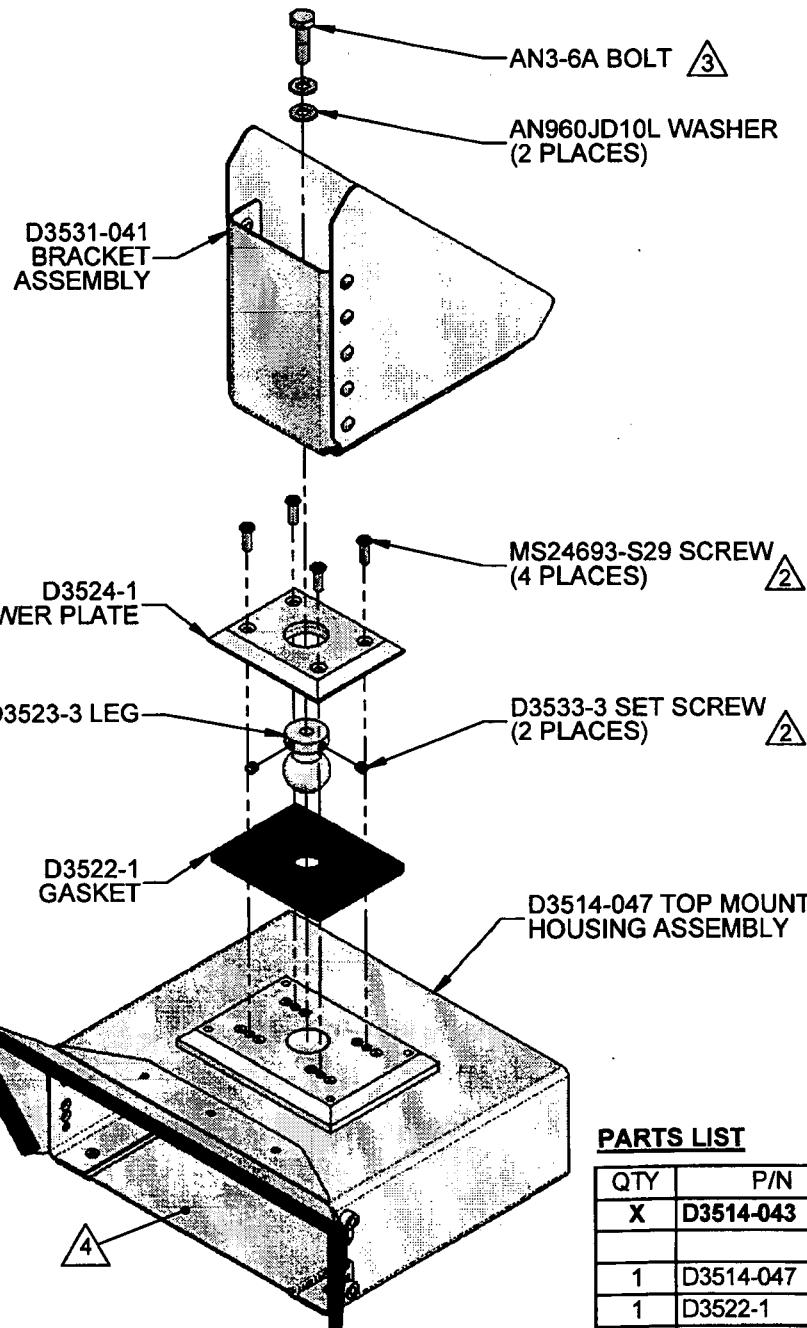
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NOTE:
 1) ASSEMBLE PER DART QSI 003
 2) TORQUE SCREWS TO 5-6 in-lbs
 3) TIGHTEN TO SNUG FIT ONLY
 4) IDENTIFY WITH DART P/N "D3514-041"
 USING A WHITE MARKER ON THE INSIDE
 OF THE HOUSING ASSEMBLY WHERE
 INDICATED

DART

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CHECKED <i>CE</i>	APPROVED <i>JH</i>	DRAWING NO. D3514	REV. A SHEET 2 OF 9
DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:3

**RELEASED**
07.08.03**D3514-043 TOP MOUNTED GIMBAL ASSEMBLY****PARTS LIST**

QTY	P/N	DESCRIPTION
X	D3514-043	TOP MOUNTED GIMBAL ASSEMBLY
1	D3514-047	TOP MOUNTED HOUSING ASSEMBLY
1	D3522-1	GASKET
1	D3523-3	LEG
1	D3524-1	LOWER PLATE
1	D3531-041	BRACKET ASSEMBLY
2	D3533-3	SET SCREW
1	AN3-6A	BOLT
2	AN960JD10L	WASHER
4	MS24693-S29	SCREW

NOTE:

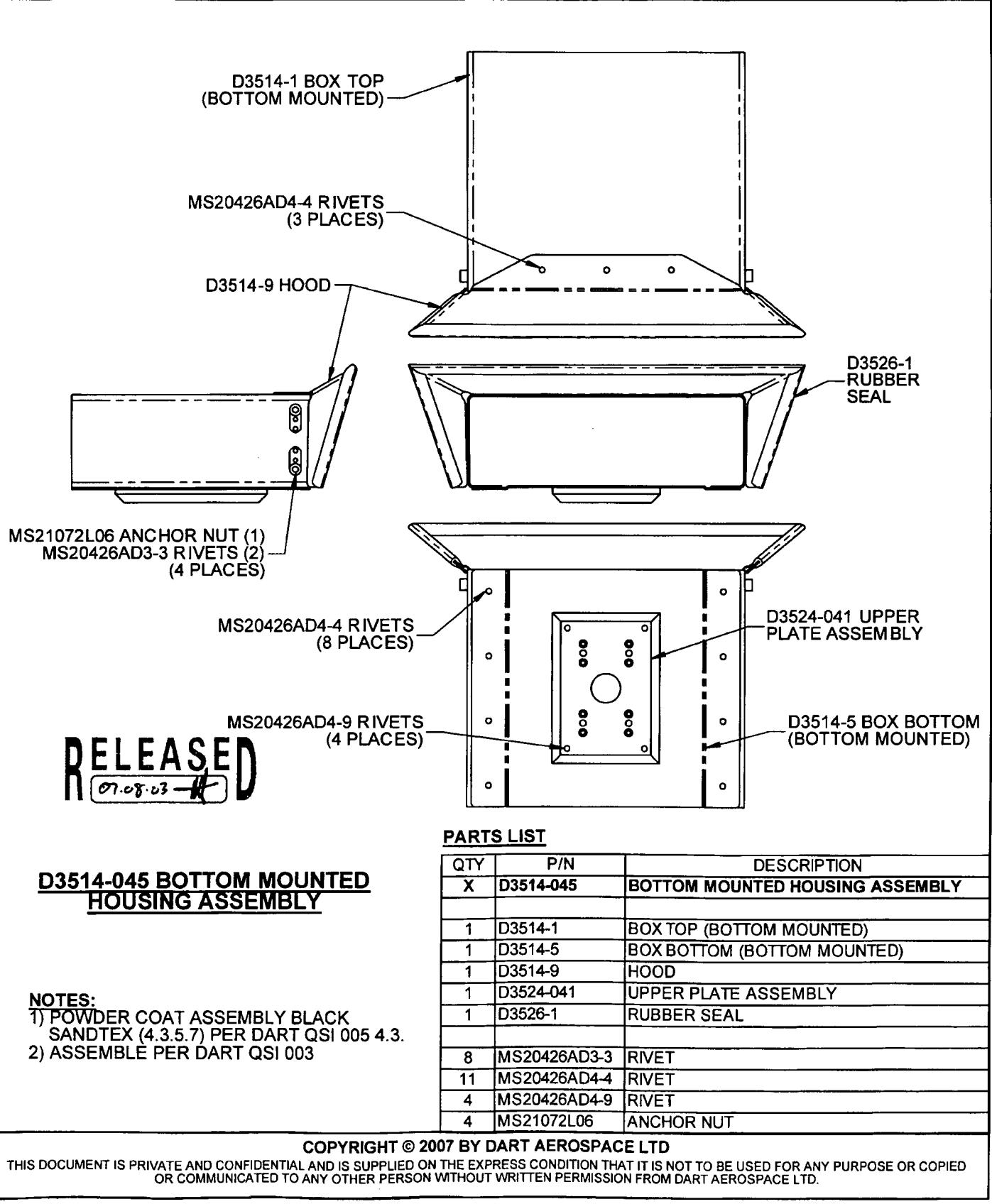
- 1) ASSEMBLE PER DART QSI 003
- 2) TORQUE SCREWS TO 5-6 in-lbs
- 3) TORQUE BOLTS TO 15-25 in-lbs
- 4) IDENTIFY WITH DART P/N "D3514-043" USING A WHITE MARKER ON THE INSIDE OF THE HOUSING ASSEMBLY WHERE INDICATED

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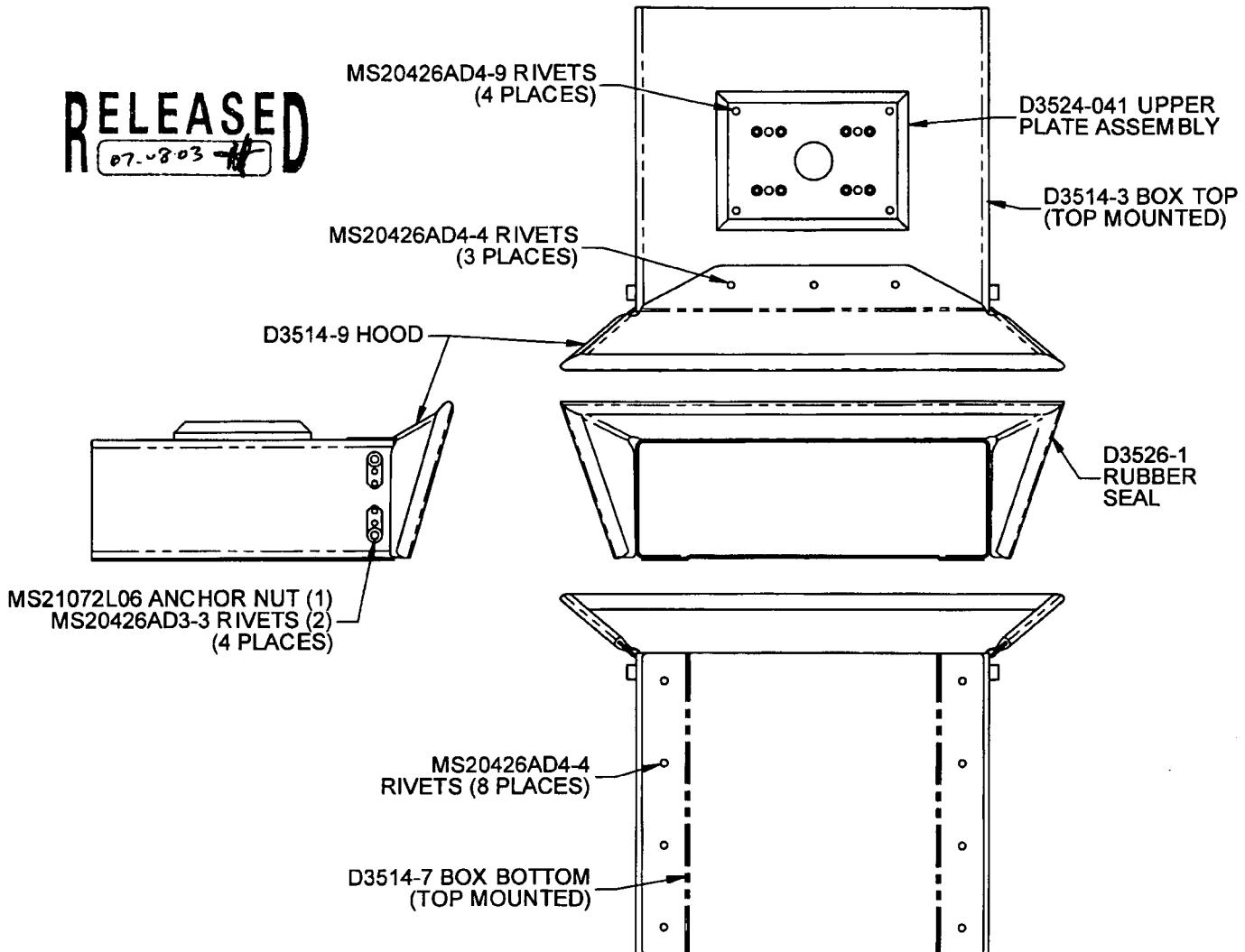
DART

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CHECKED <i>CE</i>	APPROVED <i>#</i>	DRAWING NO. D3514	REV. A SHEET 3 OF 9
DATE 07.06.18	TITLE GPS RECEIVER HOUSING	SCALE 1:3	



DART

DESIGN <i>CB</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>MM</i>	DRAWING NO. D3514	REV. A SHEET 4 OF 9
DATE 07.06.18	TITLE GPS RECEIVER HOUSING	SCALE 1:3	

RELEASED
07-08-03**D3514-047 TOP MOUNTED HOUSING ASSEMBLY****NOTES:**

- 1) POWDER COAT ASSEMBLY BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3.
- 2) ASSEMBLE PER DART QSI 003

PARTS LIST

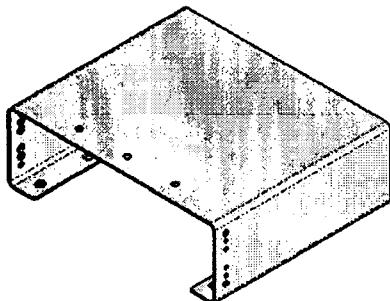
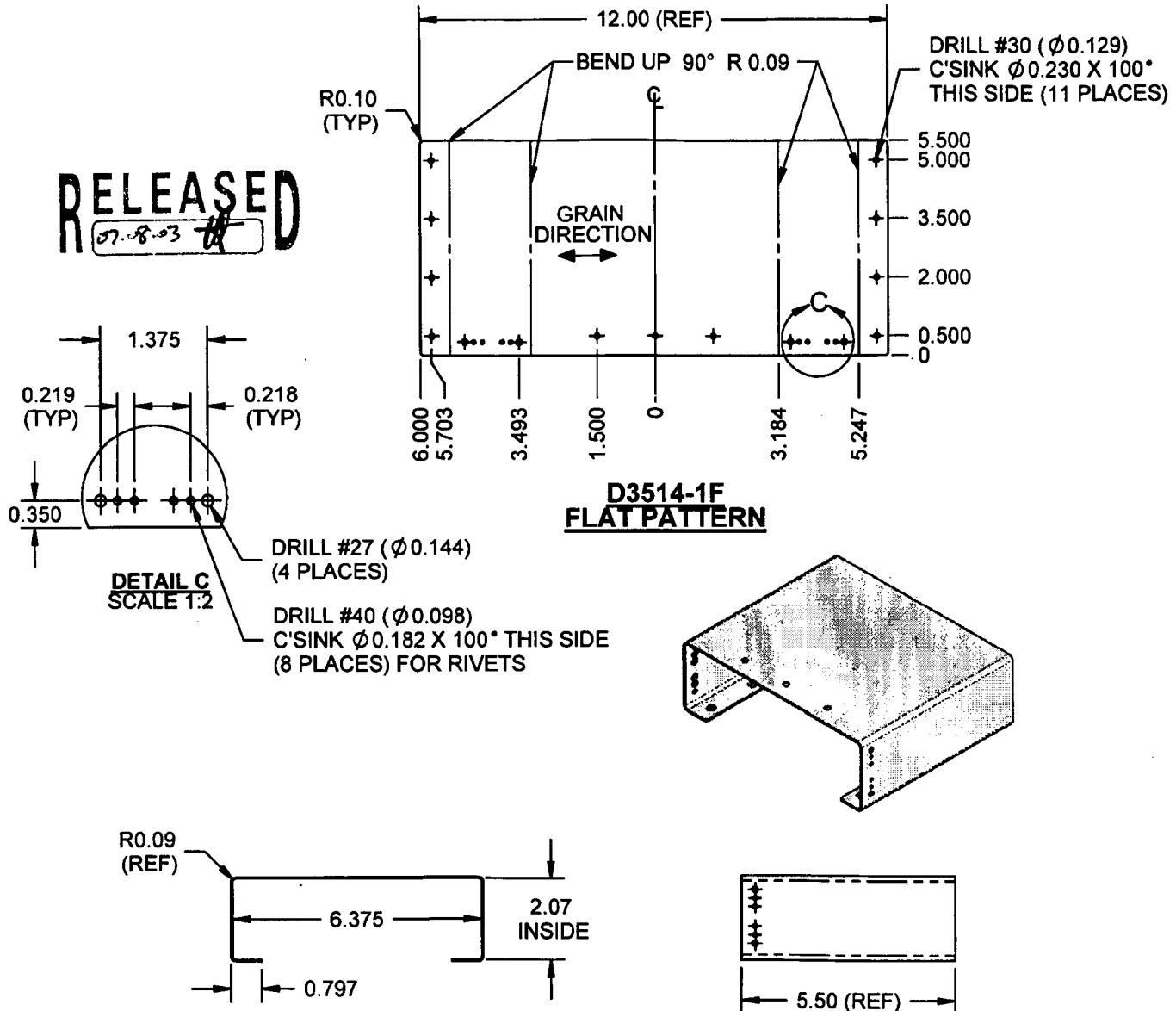
QTY	P/N	DESCRIPTION
X	D3514-047	TOP MOUNTED HOUSING ASSEMBLY
1	D3514-3	BOX TOP (TOP MOUNTED)
1	D3514-7	BOX BOTTOM (TOP MOUNTED)
1	D3514-9	HOOD
1	D3524-041	UPPER PLATE ASSEMBLY
1	D3526-1	RUBBER SEAL
8	MS20426AD3-3	RIVET
11	MS20426AD4-4	RIVET
4	MS20426AD4-9	RIVET
4	MS21072L06	ANCHOR NUT

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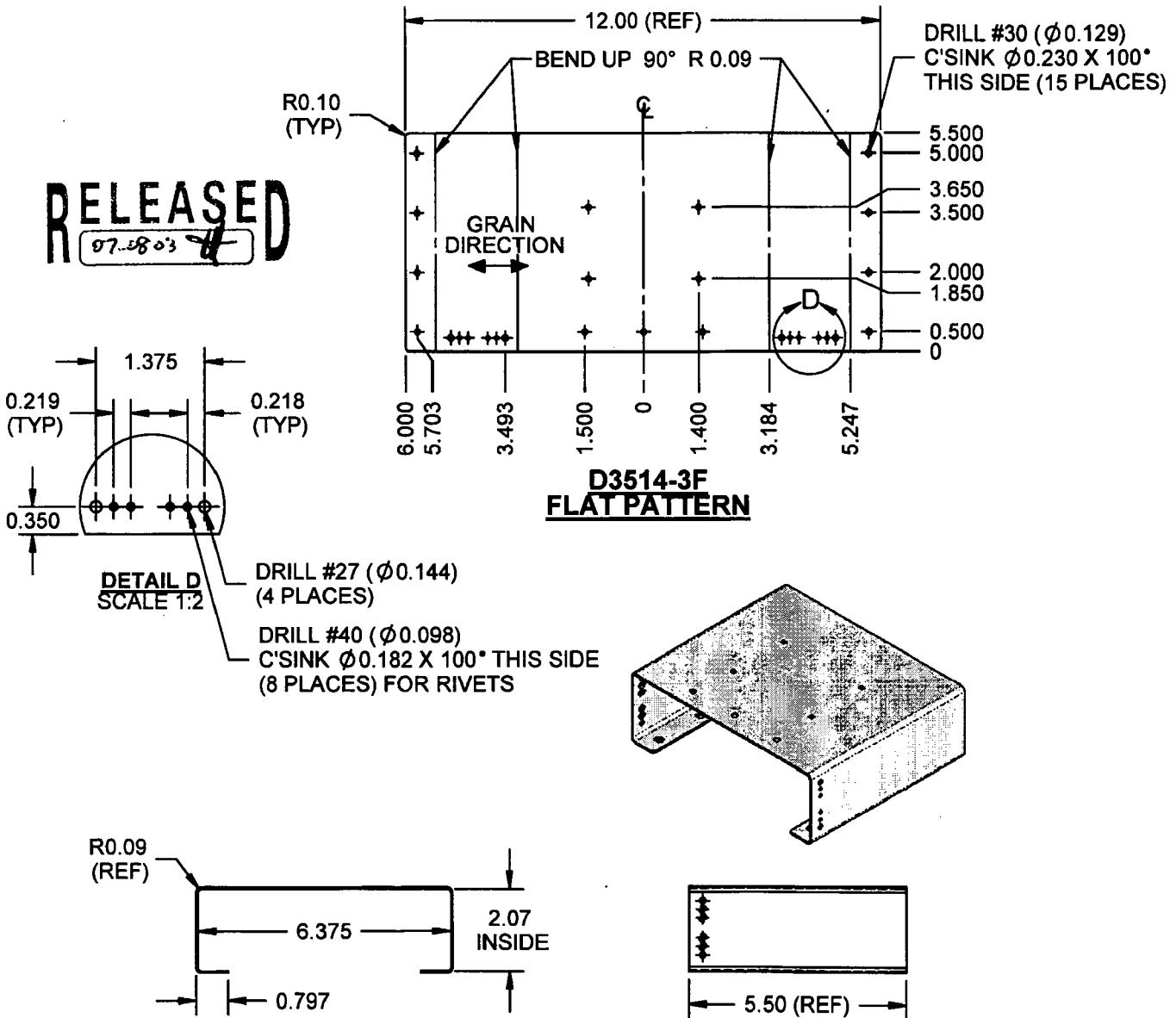
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CHECKED <i>LE</i>	APPROVED <i>JH</i>	DRAWING NO. D3514	REV. A SHEET 5 OF 9
DATE 07.06.18	TITLE GPS RECEIVER HOUSING	SCALE 1:4	

RELEASED
07-08-03 *[Signature]***D3514-1 BOX TOP (BOTTOM MOUNTED)****NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT C
- 7) C'SINKS ARE ON THE INSIDE OF PART (AFTER BENDING)

DART

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CHECKED <i>CE</i>	APPROVED <i>AT</i>	DRAWING NO. D3514	REV. A SHEET 6 OF 9
DATE 07.06.18	TITLE GPS RECEIVER HOUSING	SCALE 1:4	

RELEASED
07-08-03**D3514-3 BOX TOP (TOP MOUNTED)****NOTES:**

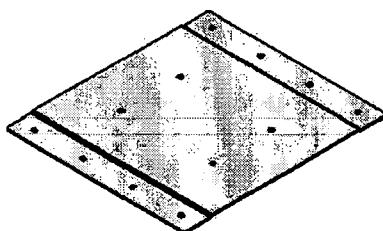
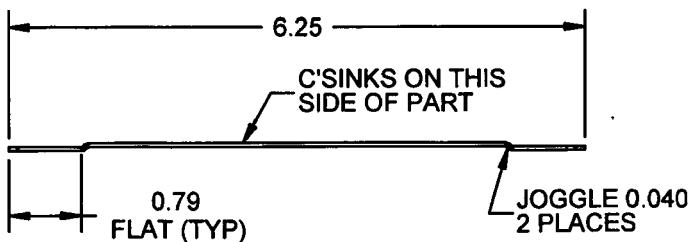
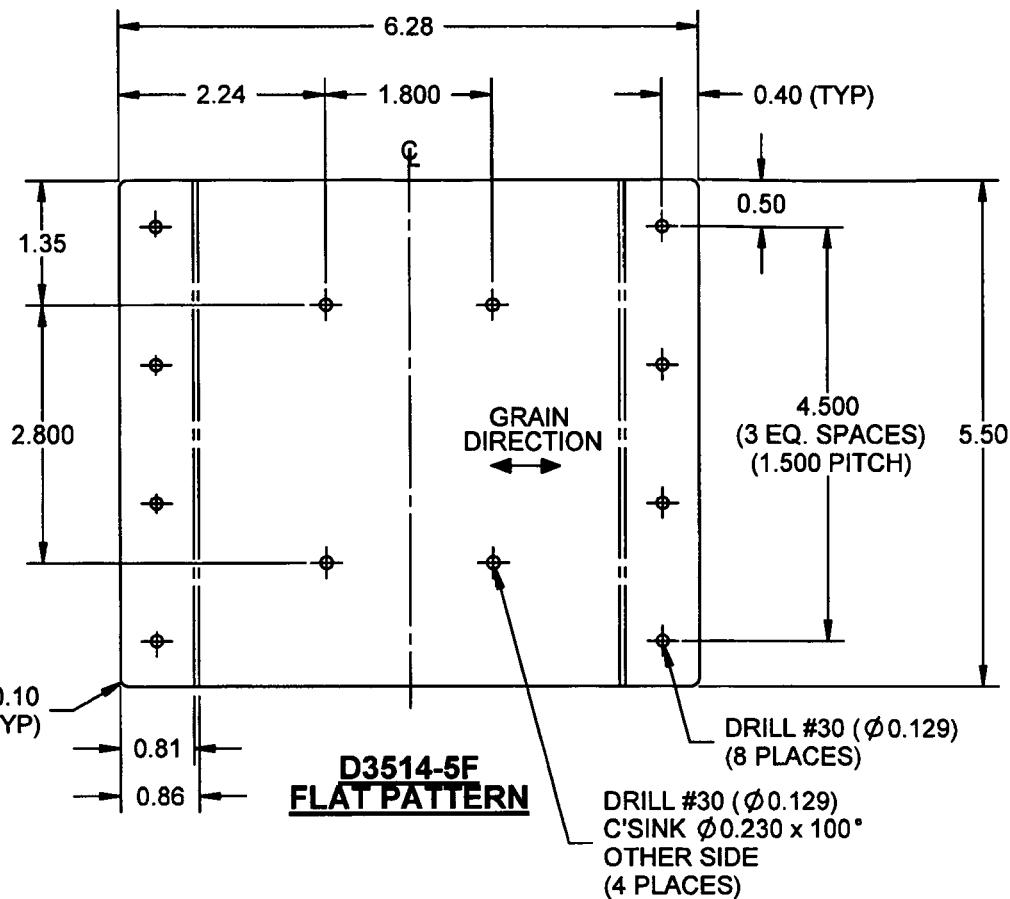
- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT Q
- 7) C'SINKS ARE ON THE INSIDE OF PART (AFTER BENDING)

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CHECKED <i>CE</i>	APPROVED <i>MM</i>	DRAWING NO. D3514	REV. A SHEET 7 OF 9
DATE 07.06.18	TITLE GPS RECEIVER HOUSING	SCALE 1:2	



D3514-5 BOX BOTTOM (BOTTOM MOUNTED)

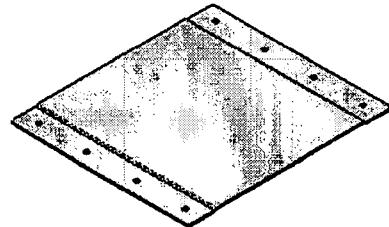
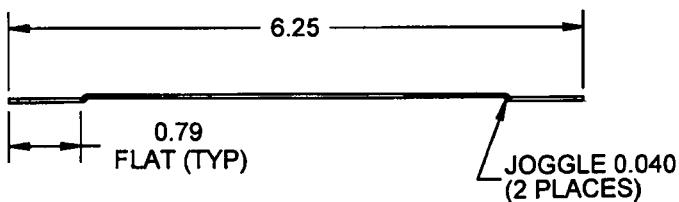
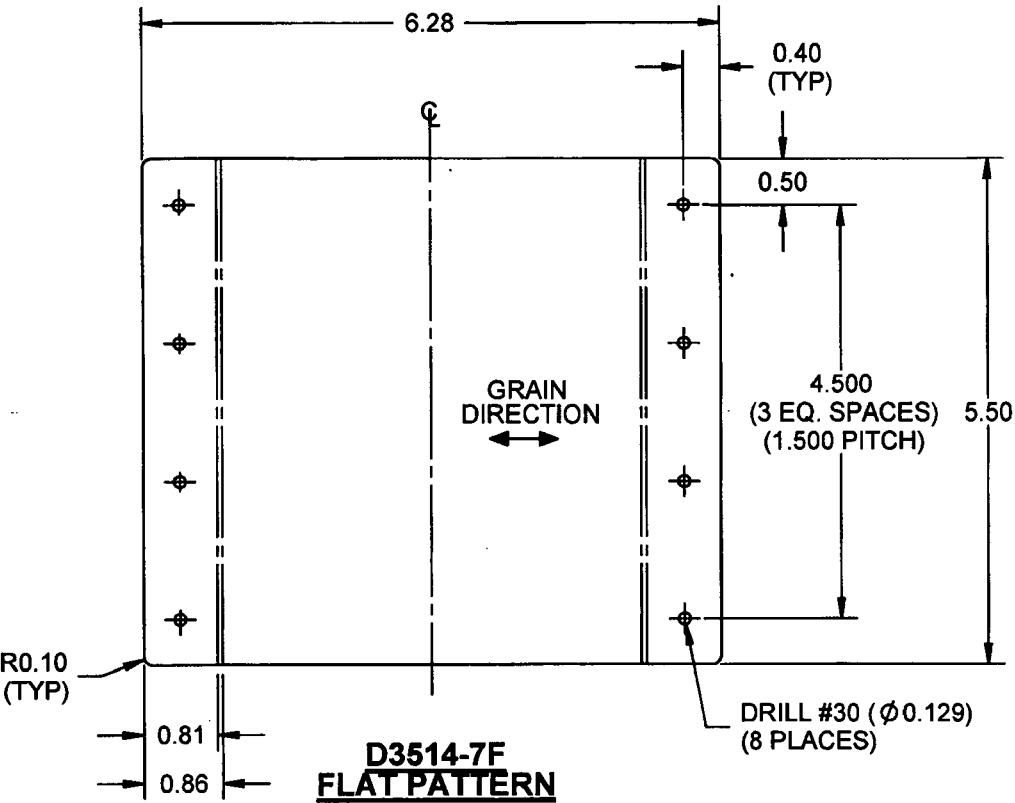
NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT $\frac{Q}{2}$
- 7) C'SINK ABOVE JOGGLE

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DATE 07.06.18	TITLE GPS RECEIVER HOUSING	REV. A SHEET 8 OF 9 SCALE 1:2



D3514-7 BOX BOTTOM (TOP MOUNTED)

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT \mathbb{C}

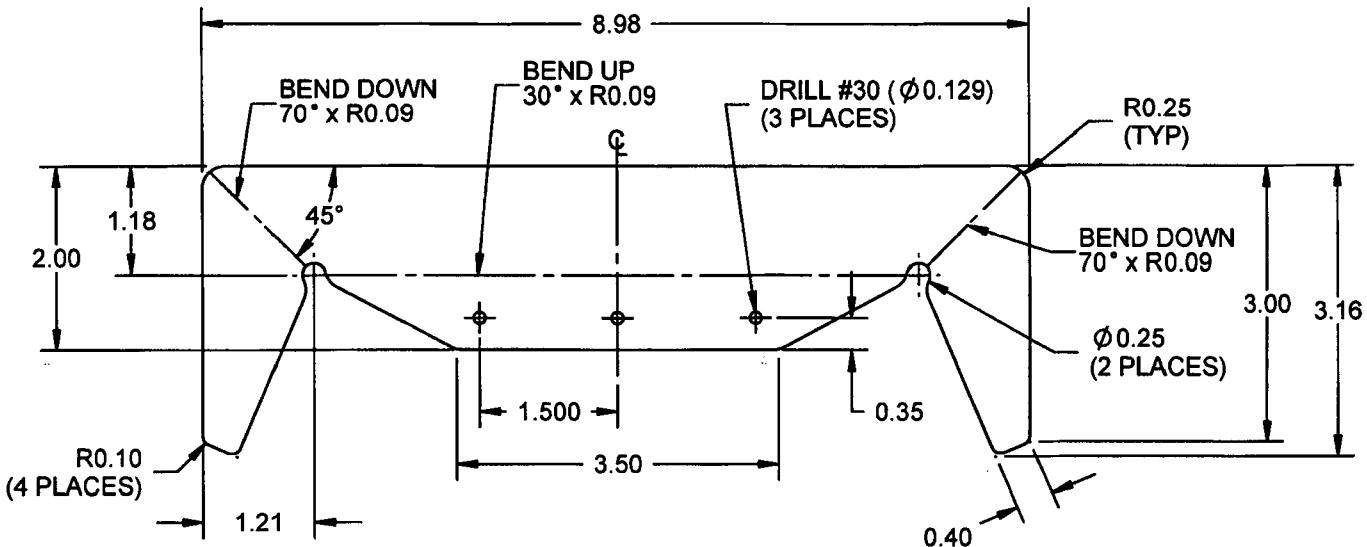
RELEASED
07-08-03 *[Signature]*

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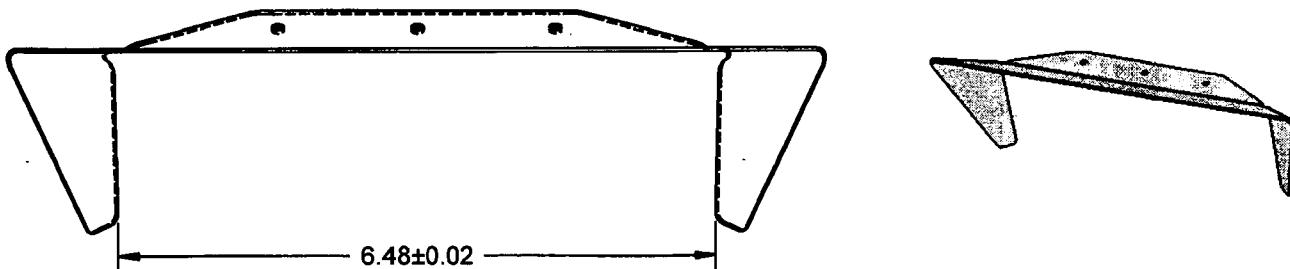
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CHECKED <i>CE</i>	APPROVED <i>MM</i>	DRAWING NO. D3514	REV. A SHEET 9 OF 9
DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:2



D3514-9F
FLAT PATTERN



FRONT VIEW

RELEASED
07.08.03

D3514-9 HOOD

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT \varnothing